

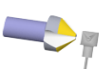


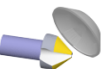






HSS Countersinkproduction Ø32 Z3

A06-310

HSS Countersinkproduction with CBN wheels can be achieved considerably fast, if the coolant pressure and quantity and the spindle power are large enough. The 3 operations flute - OD - End are shown in the pictures.



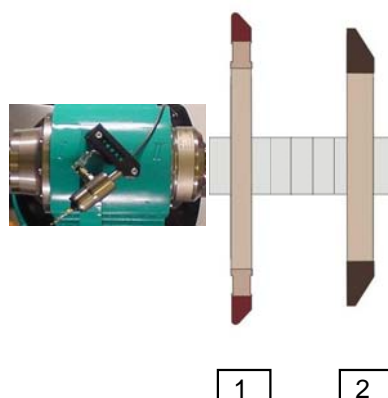
1. Cycletime for Production

Workpiece: Ø 32 mm, Z 3, Length 8 mm, Cam-relief: 0.5 to 1° Material HSS						
Operations						
Probe						
Feed [mm/Min]	2000	160	300	280	100	9000
Power [kW]		16	2	1	2	1
Cutting feed [m/s]		42	32	32	32	
Used wheels						
Grinding time [s]	8	74	28	47	38	19
Total cycle time	3 Min 33					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø250 B126 45°
2	1V1 Ø250 B126 45°



3. Machine and Software Requirements

Machines:	5 axes CNC grinders : GEMINI DMR 26	Coolant:	Synthetic Oil, pressure 16 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:	Robot, dress		
Responsible engineer:	OP. 14.4.11		

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